

5/29

DART AEROSPACE LTD	Work Order:	23627
Description: Bracket Assembly	Part Number:	D2804-042
Dwg: D2804 Rev. B	Qty:	10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required		05.06.21	10																				
2	GA	Press D2805-2 into arm as per Dwg D2804 Pick: <table border="1"><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2804-2</td><td>Bracket</td><td>B21305</td></tr><tr><td>1</td><td>D2805-2</td><td>Stop</td><td>B23637</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>R22529, B22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2804-2	Bracket	B21305	1	D2805-2	Stop	B23637	1	D2809	Bushing	R22529, B22529							
Qty	Part Number	Description	Batch																						
1	D2804-2	Bracket	B21305																						
1	D2805-2	Stop	B23637																						
1	D2809	Bushing	R22529, B22529																						
3	QC5	Inspect work to Step 2																							
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3																							
5	QC3	Inspect Powder Coat																							
6	GA	Press D2809 into arm as per Dwg D2804																							
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 Pick: <table border="1"><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td></td></tr><tr><td>2</td><td>MS21043-3</td><td>Nut</td><td></td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td></td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td></td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt		2	MS21043-3	Nut		4	NAS1515H3	Washer		A/R	LPS-3	Corrosion Spray				
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt																							
2	MS21043-3	Nut																							
4	NAS1515H3	Washer																							
A/R	LPS-3	Corrosion Spray																							
8	GA	Assemble as per Dwg D2804.																							
9	QC5	Inspect work to Step 8																							
10	ST	Identify and Stock																							
11	AC	Cost / part: _____																							
12	DC	Close W/O Inspect Level 21																							

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

RELEASED
05.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005
03:23 pm

Work Order No	:	0023627	Department Code:	
Project Name	:	D2804-042	Burden Flags	: NNNNNNN
Project For	:	WK529	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2804-042	Invoice Number	:
Description	:	Bracket Assembly	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	10	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	06-20-05	Est Mark Up	: 0.000%
Est Finish Date	:	07-21-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

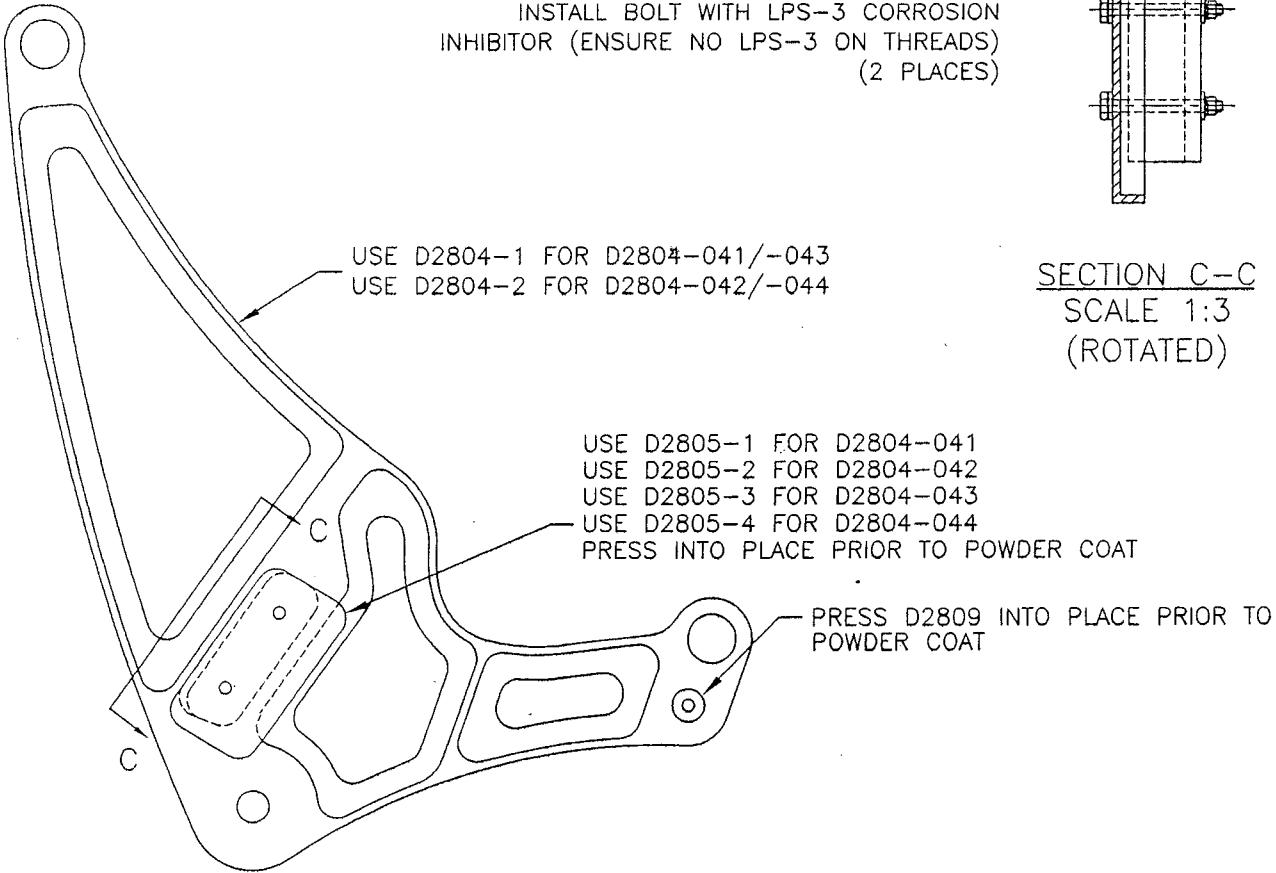
	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

CONTROLLED COPY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

05-03-11 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN),
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

✓
Nov 08, 2005
10:31 am

Work Order No : 0023627
 Project Name : D2804-042
 Project For : WK529
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2804-042
 Description : Bracket Assembly
 Manufactured : Yes
 Amount Req'd : 10
 Amount Done : 0
 Start Date : 06-20-05
 Est Finish Date : 07-21-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.25	100.00		
Production Cost :	0.00	6.03	100.00	0.00	6.03
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	6.03	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	6.03			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	(-6.03)

MWS 0/0
u
W.13

Date: Monday, 14/11/2005 8:52:16 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 23627			Part Number	: D2804042		
Estimate Number	: 10334			Drawing Number	: D2804 REV B		
P.O. Number	:			Project Number	:		
This Issue	: 14/11/2005	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: R & D SM/MED FAB	Due Date	: 15/12/2005	Qty:	10
Previous Run	:			Um:	Each		
Written By	:			KJ/JLM			
Checked & Approved By	:						
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28042	STA 155 Bracket
2.0	D28052	Stop
3.0	D2809	Bushing
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2804

5.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

6.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	AN3C16A	Bolt
9.0	MS210433	Nut
10.0	NAS1515H3	Washer
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

Date: Monday, 14/11/2005 8:52:16 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 23627

Part Number: D2804042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

